



29

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>21184</b>
<b>Description:</b> Bearpaw Kit (13" x 16")	<b>Part Number:</b>	<b>K10005</b>
<b>Dwg:</b> D2671 Rev. B1	<b>Qty:</b>	<b>4 Kits</b>
<b>Ref:</b> K10005 Rev. A; DSK086-1 Rev. A	<b>Page 1 of 1</b>	

Step	Location	Procedure	By	Date	Qty																																																
1	DC	Issue Traveler <b>Note: (1) K10005 Kit consists of Qty (2) D2671</b> <b>Dwg not required</b>	HA	04.07.05	4																																																
2	DC	Photocopy bluefile: K10005 D206-559-021 D500-572-021 and create labels per PPP K10005 CHG002 <b>(Bag Bluefiles separately)</b>	HA DK	04.07.07	4																																																
3	GA	<b>Cut 2 blanks per (1) K10005 Kit</b> Cut blank: 13.25" x 16.00" x 1.00" thick (+0.030/-0.000) per; DSK086-1 Material: Black UHMW 1" (MUHMWB10) Batch: <u>m15625</u>	En	04.07.21	4																																																
4	MV	Inspect material for defects or damage prior to machining	En	04.07.21	4																																																
5	MV	Machine as per Folio and Dwg D2671 <b>Identify as D2671</b>	En	04.08.03	4																																																
6	QC2	Inspect parts as they come off the CNC machine	En	04.08.03	4																																																
7	MV	Deburr	En	04.08.03	4																																																
8	QC8 & 5	Second inspection	En	04.08.03	4																																																
9	KP	<b>Pick: Packing Kit (Note: D2671 is on the BOM as material from step 3)</b> <table><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>4</td><td>D2182B050</td><td>Rubber Cushion</td><td>B20434</td></tr><tr><td>8</td><td>D2274</td><td>Radius Block</td><td>B20655</td></tr><tr><td>2</td><td>D2671</td><td>Bearpaw</td><td>B21184</td></tr><tr><td>4</td><td>D2438</td><td>Clamp</td><td>B4734, B5375, B12162, B88165, B19115, B209634</td></tr><tr><td>8</td><td>D2529</td><td>Washer</td><td>B209644</td></tr><tr><td>8</td><td>AN4-15A</td><td>Bolt</td><td>m14544</td></tr><tr><td>8</td><td>AN4-17A</td><td>Bolt</td><td>m14311</td></tr><tr><td>16</td><td>AN960JD416</td><td>Washer</td><td>m15020</td></tr><tr><td>8</td><td>MS21042L4</td><td>Nut (or -4)</td><td>m14478</td></tr><tr><td>2</td><td>QS200M44S</td><td>Clamp</td><td>m15364</td></tr><tr><td>1</td><td colspan="3">Paperwork package from Step 2</td></tr></tbody></table>	Qty	Part Number	Description	Batch	4	D2182B050	Rubber Cushion	B20434	8	D2274	Radius Block	B20655	2	D2671	Bearpaw	B21184	4	D2438	Clamp	B4734, B5375, B12162, B88165, B19115, B209634	8	D2529	Washer	B209644	8	AN4-15A	Bolt	m14544	8	AN4-17A	Bolt	m14311	16	AN960JD416	Washer	m15020	8	MS21042L4	Nut (or -4)	m14478	2	QS200M44S	Clamp	m15364	1	Paperwork package from Step 2			En	04.08.03	4
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10	QC4	Inspect Kit for 100% Completeness on the W/O	En	04.08.03	4																																																
11	PK	Identify and pack for shipping as per PPP K10005 <b>Rev.C</b>	En	04.08.04	4																																																
12	AC	Cost / part <u>182.90</u>	En	04.08.05	4																																																
13	DC	Close W/O <u>170.59</u> Inspect Level 21	HA	04.08.10	4																																																

Rev	Date	Change	Revised By	Approved
A	99.12.17	K10005 created for Bearpaw Kit	EC	
B	03.05.28	Reformat; Incorporated D2671	KJ/RF	
C	04.02.17	Blank size changed	KJ/JLM	

**RELEASED**  
04.02.20

Work Order:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector
010803	5	One extra bearing was machined for a total of 9 instead of 8. Put one bearing in stores & identify as D2671 B21184	CL	04/08/11	1	 04.08.03	 04.08.03

NCR		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial					

PAR#: \_\_\_\_\_ Fault Category: \_\_\_\_\_ DQA: \_\_\_\_\_ Date: \_\_\_\_\_

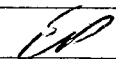

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_


DART AEROSPACE LTD		Work Order:	21184
Description: Bearpaw		Part Number:	D2671
Inspection Dwg: D2671 Rev: B1		Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.063x45	✓		vern	
B	5.500	+/-0.030	5.507	✓		vern	
C	0.200	+/-0.030	0.198	✓		Depth mic	
D	R0.250	+/-0.030				R.G	
E	0.625	+/-0.030	0.631	✓		mic	
F	0.250	+/-0.010	0.265	✓		mic	
G	0.950	+0.030/-0.010	0.955	✓		mic	
H	0.25 x 45°	+/-0.030	0.23x45°	✓		vern	
I	0.375	+/-0.010	0.372	✓		vern	
J	12.750	+/-0.030	12.750	✓		Tape measure	
K	Ø0.260	+0.005/-0.000	Ø0.260	✓		vern	
L	Ø0.93	+/-0.030	Ø0.925	✓		vern	
M	0.30	+0.030/-0.000	0.308	✓		Depth mic	
N	4.250	+/-0.030	4.250	✓		vern	
O	0.375	+/-0.030	0.388	✓		vern	
P	2.000	+/-0.030	2.001	✓		vern	
Q	4.250	+/-0.010	4.259	✓		vern	
R	9.000	+/-0.010	9.010	✓		vern	
S	15.750	+/-0.030	15.750	✓		Tape measure	

Measured by: 	Audited by: 	Prototype Approval:	N/A
Date: 24/07/21	Date: 04.08.23	Date:	

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/C K 10005	KJ/RF	

RELEASED

04.01.15

# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Jul 01, 2004  
02:00 pm

Work Order No : 0021184  
Project Name : K10005  
Project For : WK429  
Work Order Type : Main  
Main WO Number :  
House Part Number : \*K10005  
Description : Bearpaw kit 13" x 16"  
Manufactured : Yes  
Amount Req'd : 4  
Amount Done : 0  
Start Date : 07-01-04  
Est Finish Date : 07-15-04  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Margin : 0.000%  
Actual Margin : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00